

Date: Monday, 4/23/2007 1:52:29 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	WEARSHOE
Job Number	31990			
Estimate Number	12736			
P.O. Number	N/A		Part Number	D353515
This Issue	4/23/2007	S.O. No.	Drawing Number	D3535 UNDER REVIEW
Prsht Rev.	NC		Project Number	N/A
First Issue	N/A	Type	Drawing Revision	X B PH 07.04.28
Previous Run	30750		Material	N/A
Written By			Due Date	4/30/2007 Qty: 25 Um: Each
Checked & Approved By	107.04.26			
Comment	Est Rev:A New Issue 07-02-15 JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S20GA	304/316 .040 Sheet
Comment: Qty.: 1.0715 sf(s)/Unit Total : 21.4305 sf(s) 304/316 .040 Sheet (M304S20GA)		SAD 07/04/28
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3535 Dwg Rev: B Prog Rev: B		SAA 07/04/28
2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		SAD 07/04/28
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK		07/04/30
5.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE 1-Form on Brake as per Dwg D3535 using Jigs DT8261and DT8326 2-Form joggle as per Dwg D3535 using Jig DT8158 3-Identify as D3535-15		SB 07/04/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 01/05/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 1:52:29 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 31990

Part Number: D353515

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



7070501 26



Comment: INSPECT WORK TO CURRENT STEP

7.0 POWDER COATING

POWDER COATING



M101601



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

18)

07-05-03

(26)

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Q6X

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m-l 07/05/04

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Q6X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

EP-15

m-l 07/05/04

10.0 QC21

FINAL INSPECTION/W/O RELEASE



(26)

Comment: FINAL INSPECTION/W/O RELEASE

18) 07/05/04

Job Completion



U 07.05.04

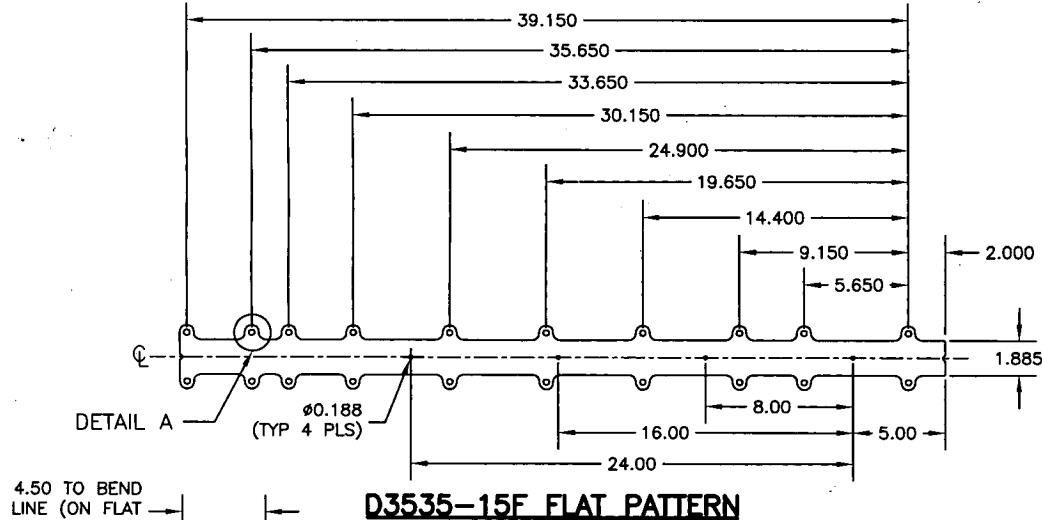
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PRELIMINARY ISSUE



D3535-15F FLAT PATTERN

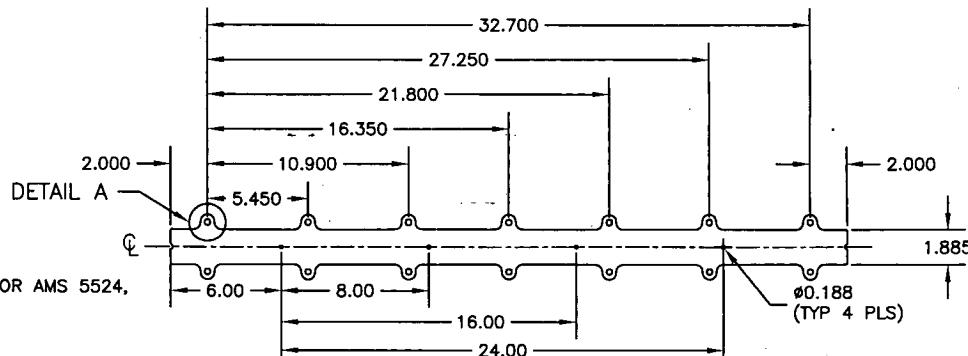


D3535-15 BEND DETAIL

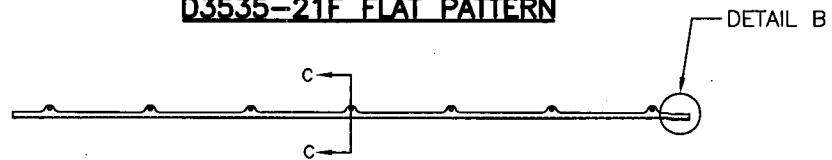
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31990

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{C}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
C.B	RH	PRT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D3535
DATE		TITLE
07.04.17		WEARSHOE
SCALE		SHEET 2 OF 7
1:10		

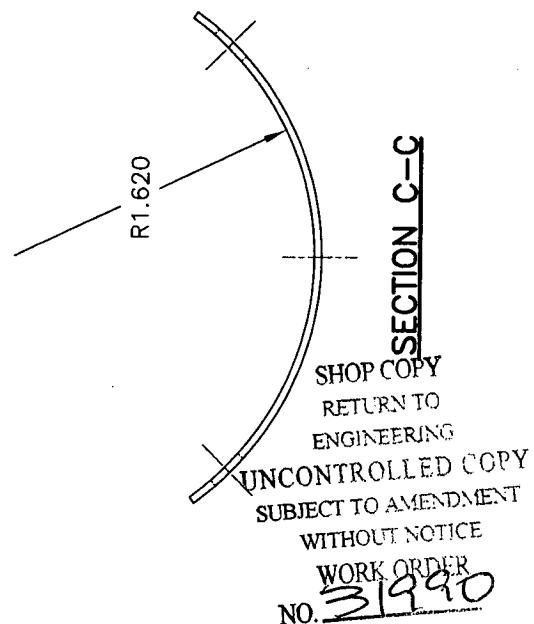
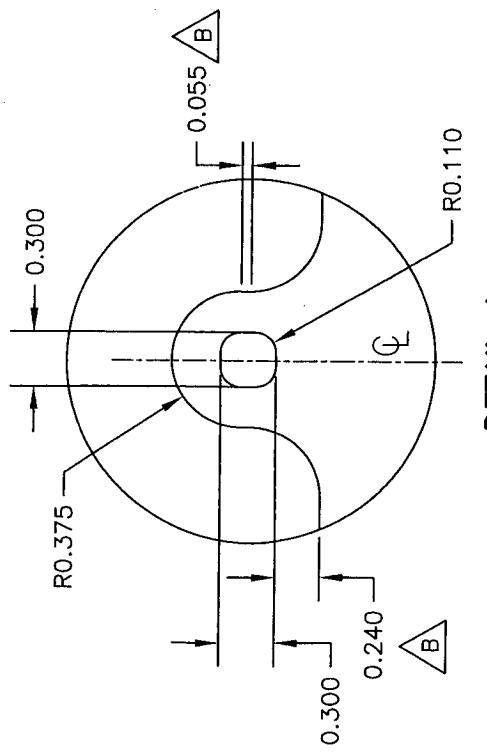
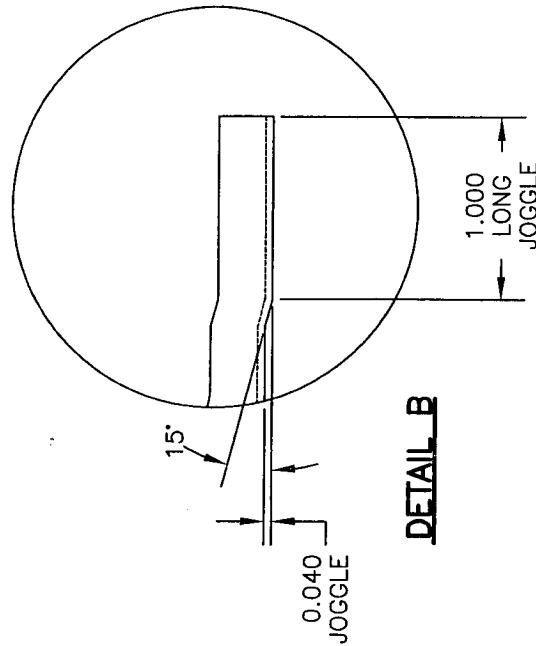
DESIGN <i>CB</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3535	SHEET 7 OF 7

DATE
07.04.17

TITLE
WEARSHOE

SCALE
1:1

PRELIMINARY ISSUE



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DART AEROSPACE LTD

Work Order: 31991

Description: WEARSHOE

Part Number: D 353521

Inspection Dwg: D 3535 Rev: B

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

 First Article Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 1.885	+/- 0.010	1.888	✓		Vern	
B 2.000	+/- 0.010	2.003	✓		Vern Vertical	
C 5.650	+/- 0.010	5.648	✓		Vern	
D 9.150	+/- 0.010	9.150	✓		M-T	
E 14.400	+/- 0.010	14.400	✓		M-T	
F 19.650	+/- 0.010	19.650	✓		M-T	
G 24.900	+/- 0.010	24.900	✓		M-T	
H 30.150	+/- 0.010	30.150	✓		M-T	
I 33.650	+/- 0.010	33.650	✓		M-T	
J 35.650	+/- 0.010	35.650	✓		M-T	
K 39.150	+/- 0.010	39.150	✓		M-T	
L Ø0.188	+0.005 -0.001	Ø0.188	✓		Vern	
M 24.00	+/- 0.030	24.00	✓		M-T	
N 16.00	+/- 0.030	16.00	✓		M-T	
O 8.00	+/- 0.070	8.00	✓		M-T	
P 5.00	+/- 0.030	5.007	✓		Vern Vertical	
Q 0.300	+/- 0.010	0.300	✓		Vern	
R 0.300	+/- 0.016	0.297	✓		Vern	
S Ø0.038	+/- 0.010	0.036	✓		Vern	
T						
U						
V						
W						
X						
Y						

Measured by: JAD
 Date: 07/04/28

Audited by: DL
 Date: 07/04/30

Prototype Approval: N/A
 Date: N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	